

Black

Dart Aerospace Ltd.

Date: Thursday, 05/02/2009 3:47:15 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : GPS RECEIVER HOUSING
 Job Number : 45563
 Estimate Number : 12517
 P.O. Number :
 This Issue : 05/02/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D3514047
 First Issue : // Type : SMALL /MED FAB Drawing Number : D3514 REV.A
 Previous Run : 35369 Project Number : N/A
 Material :
 Due Date : 03/03/2009 Qty: 3 Um: Each
 Written By :
 Checked & Approved By : JUD 09.02.06
 Comment : Est Rev:A New Issue 07-09-24 EC verified by DD

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D35143	Box Top (Top Mounted)
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) BOX TOP (BOTTOM MOUNTED) 3 Batch: B 35374 FF 09/02/23 (3)		
2.0	D35147	Box Bottom (Top Mounted)
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) BOX BOTTOM (BOTTOM MOUNTED) 3 Batch: B 35375 FF 09/02/23 (3)		
3.0	D35149	Hood
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) HOOD 3 Batch: B 35376 FF 09/02/23 (3)		
4.0	D3524041	Upper Plate Assembly
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) UPPER AND LOWER PLATE 3 Batch: B 34824 FF 09/02/23 (3)		
5.0	MS20426AD33	Rivet
Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s) RIVET 24 Batch: M1563 FF 09/02/23 (3)		



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 05/02/2009 3:47:15 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GPS RECEIVER HOUSING

Job Number: 45563

Part Number: D3514047

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	MS20426AD44	Rivet
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Comment: Qty.: 11.0000 Each(s)/Unit Total: ~~44.0000~~ Each(s)
Rivet 33
Batch: M15541

FF 09/09/23 (3)

7.0	MS20426AD49	RIVET
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Comment: Qty.: 4.0000 Each(s)/Unit Total: ~~16.0000~~ Each(s)
RIVET 12
Batch: M18136

FF 09/02/23 (3)

8.0	MS21072L06	ANCHOR NUT
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Comment: Qty.: 4.0000 Each(s)/Unit Total: ~~16.0000~~ Each(s)
ANCHOR NUT 12
Batch: 101760

FF 09/02/23 (3)

9.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per dwg D3514

FF 09/02/23 (3)

10.0	QC5	INSPECT WORK TO CURRENT STEP
------	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

5 09/02/23 (X3)

11.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING
Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME: 8:00am
OVEN TEMPERATURE: 320 °F
FINISH TIME: 8:30am

FF 09-02-24 (X3)

12.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
------	-----	---



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FF 09-02-24 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 05/02/2009 3:47:15 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GPS RECEIVER HOUSING

Job Number: 45563

Part Number: D3514047

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble trim as per dwg D3514

FF 09/02/24 (3)

14.0

D35261

Rubber Seal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
RUBBER SEAL
Batch: B25377

FF 09/02/24 (3)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 09/02/24 (3)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: GA

SB 09/02/24 (3)

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/24 A

Job Completion



MF 09-02-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

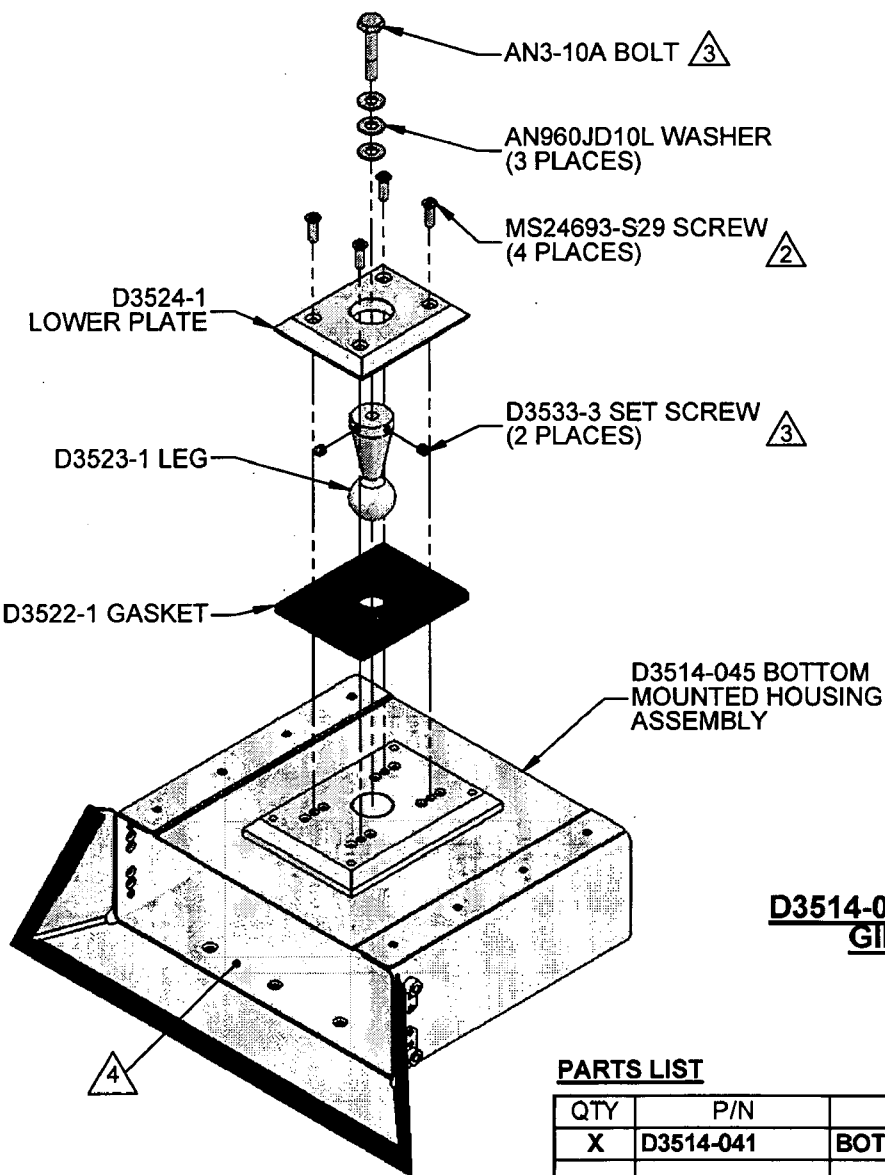
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED CE	APPROVED [Signature]	DRAWING NO. D3514
DATE 07.06.18		REV. A SHEET 1 OF 9
TITLE GPS RECEIVER HOUSING		SCALE 1:3
REV A	DATE 07.06.18	DESCRIPTION NEW ISSUE



RELEASED
07.08.03

SHOP COPY
RETURN TO
ENGINEERING
D3514-041 BOTTOM MOUNTED GIMBAL ASSEMBLY COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **45563**

PARTS LIST

QTY	P/N	DESCRIPTION
X	D3514-041	BOTTOM MOUNTED GIMBAL ASSEMBLY
1	D3514-045	BOTTOM MOUNTED HOUSING ASSEMBLY
1	D3522-1	GASKET
1	D3523-1	LEG
1	D3524-1	LOWER PLATE
2	D3533-3	SET SCREW
1	AN3-10A	BOLT
3	AN960JD10L	WASHER
4	MS24693-S29	SCREW

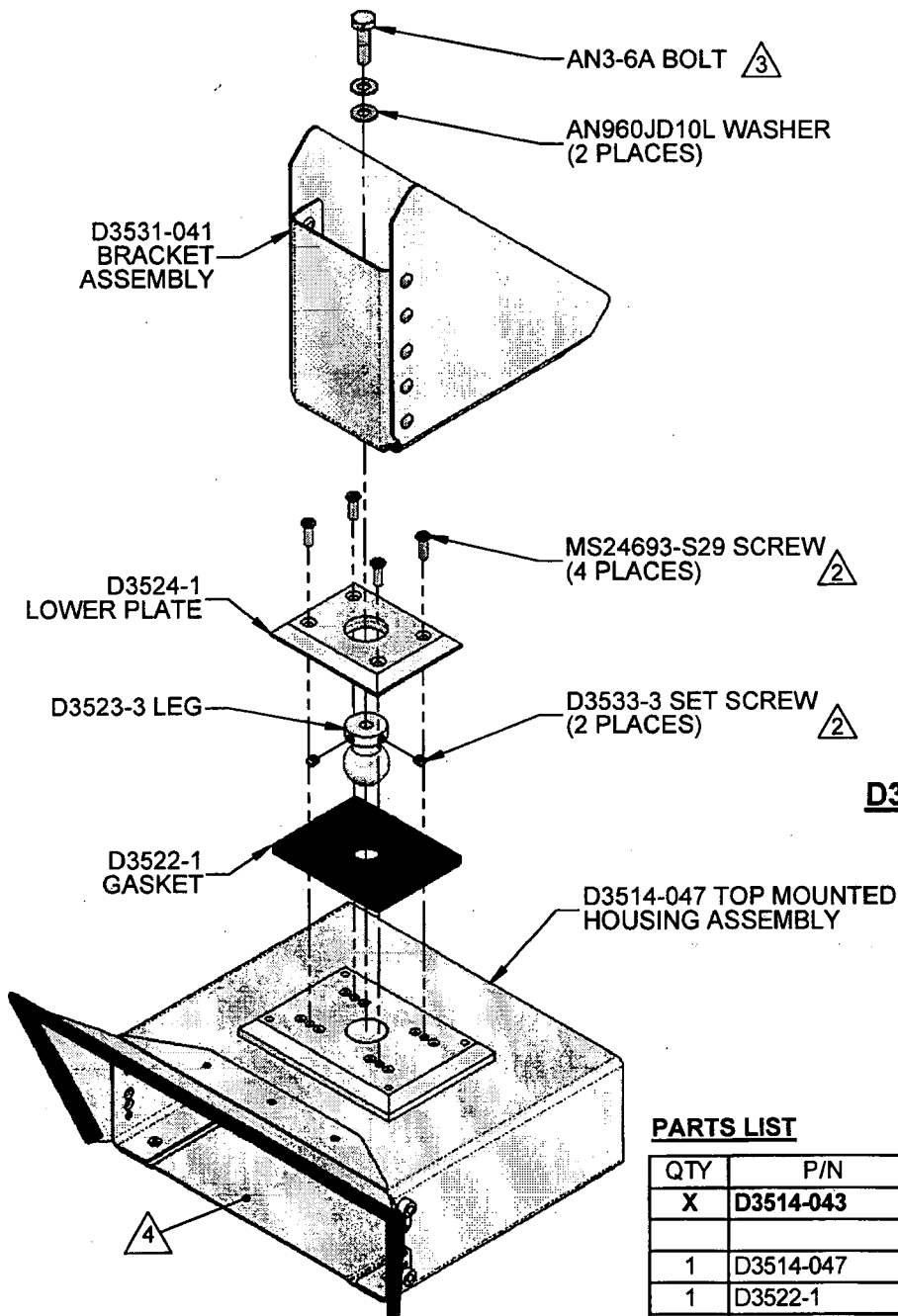
NOTE:
1) ASSEMBLE PER DART QSI 003
2) TORQUE SCREWS TO 5-6 in-lbs
3) TIGHTEN TO SNUG FIT ONLY
4) IDENTIFY WITH DART P/N "D3514-041" USING A WHITE MARKER ON THE INSIDE OF THE HOUSING ASSEMBLY WHERE INDICATED

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DATE 07.06.18	TITLE GPS RECEIVER HOUSING		SHEET 2 OF 9 SCALE 1:3



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**D3514-043 TOP MOUNTED
GIMBAL ASSEMBLY**

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NO. 45563

PARTS LIST

QTY	P/N	DESCRIPTION
X	D3514-043	TOP MOUNTED GIMBAL ASSEMBLY
1	D3514-047	TOP MOUNTED HOUSING ASSEMBLY
1	D3522-1	GASKET
1	D3523-3	LEG
1	D3524-1	LOWER PLATE
1	D3531-041	BRACKET ASSEMBLY
2	D3533-3	SET SCREW
1	AN3-6A	BOLT
2	AN960JD10L	WASHER
4	MS24693-S29	SCREW

NOTE:

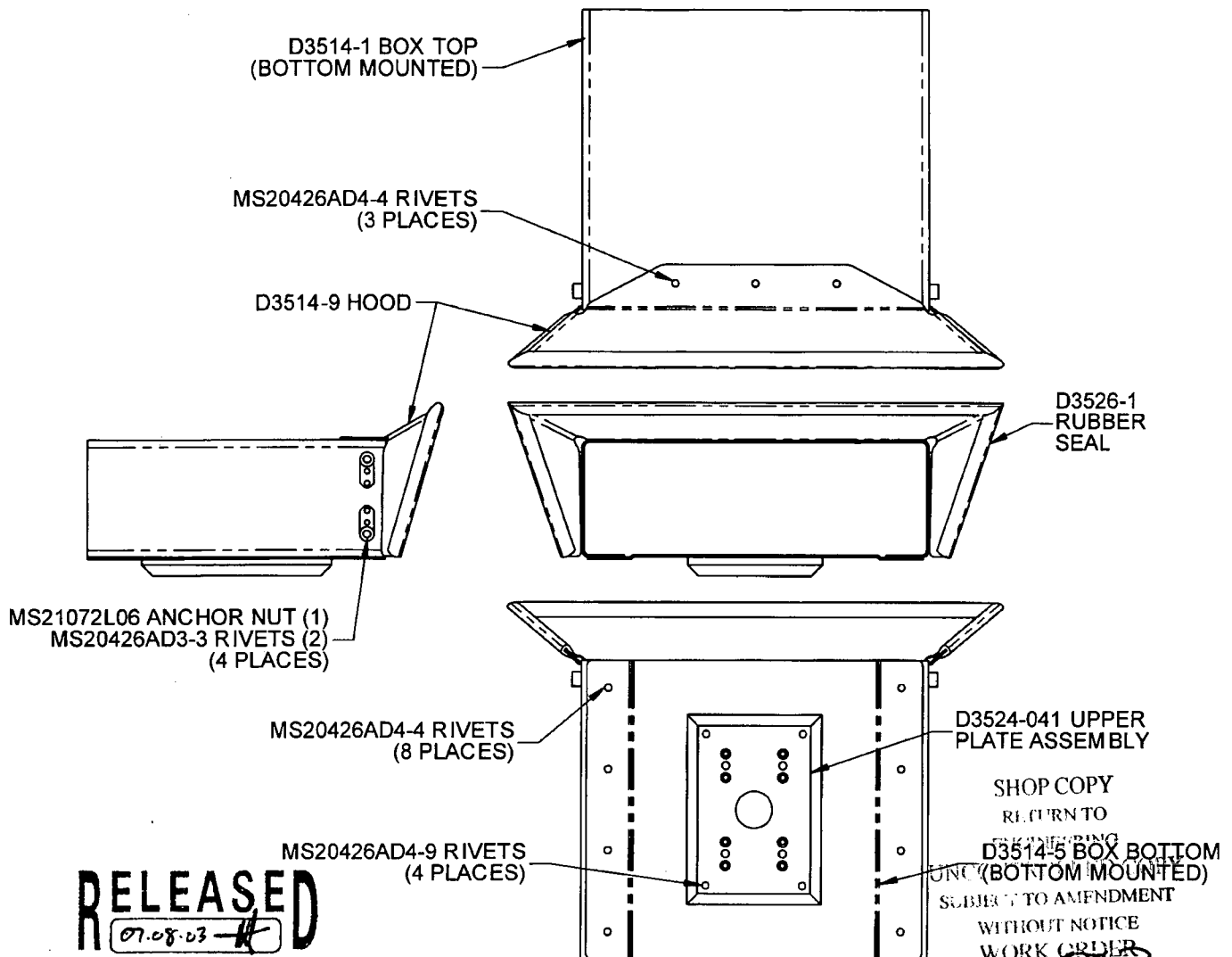
- 1) ASSEMBLE PER DART QSI 003
- 2) TORQUE SCREWS TO 5-6 in-lbs
- 3) TORQUE BOLTS TO 15-25 in-lbs
- 4) IDENTIFY WITH DART P/N "D3514-043" USING A WHITE MARKER ON THE INSIDE OF THE HOUSING ASSEMBLY WHERE INDICATED

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DATE 07.06.18		TITLE GPS RECEIVER HOUSING	SCALE 1:3



**D3514-045 BOTTOM MOUNTED
HOUSING ASSEMBLY**

NOTES:

- 1) POWDER COAT ASSEMBLY BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3.
- 2) ASSEMBLE PER DART QSI 003

PARTS LIST

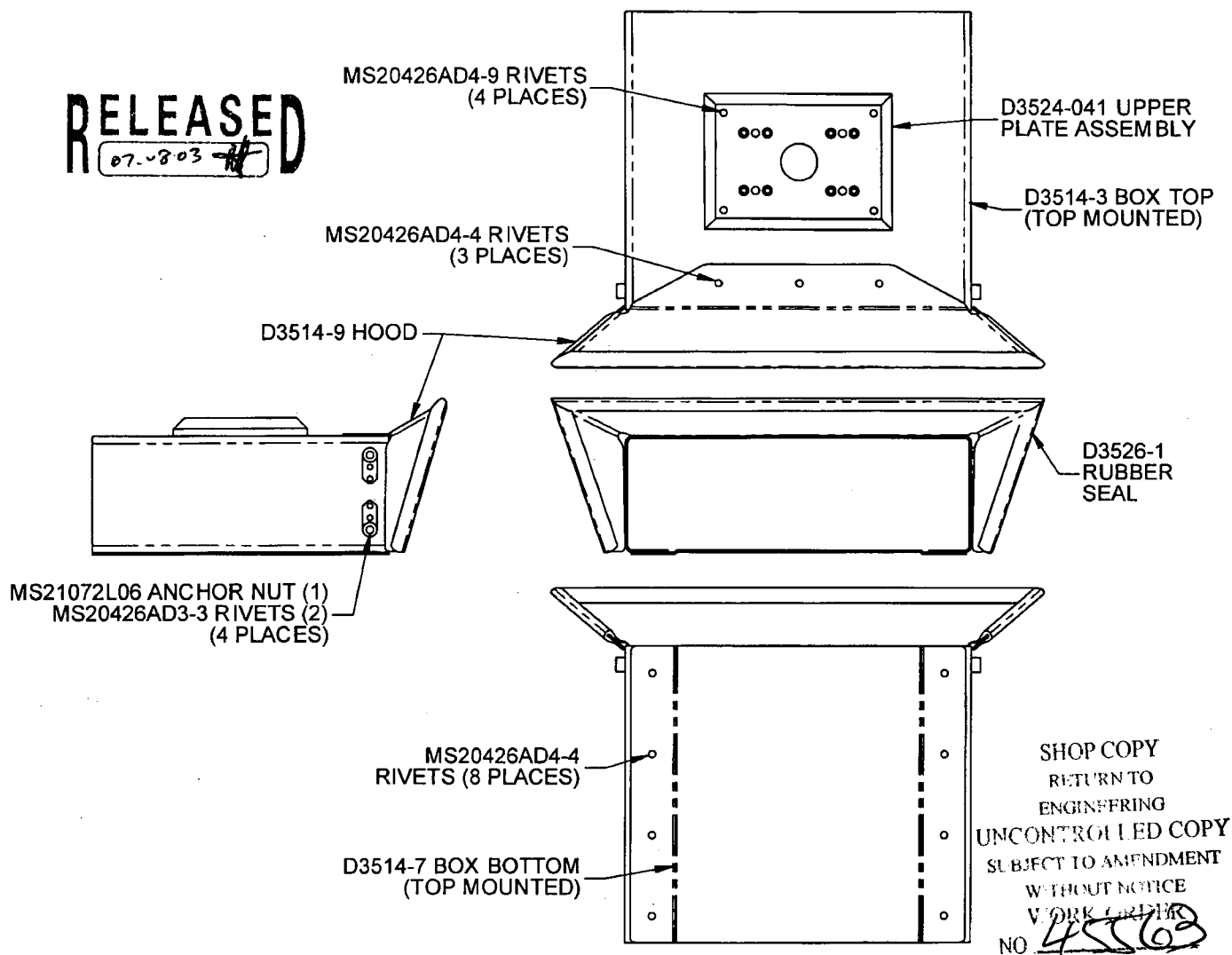
QTY	P/N	DESCRIPTION
X	D3514-045	BOTTOM MOUNTED HOUSING ASSEMBLY
1	D3514-1	BOX TOP (BOTTOM MOUNTED)
1	D3514-5	BOX BOTTOM (BOTTOM MOUNTED)
1	D3514-9	HOOD
1	D3524-041	UPPER PLATE ASSEMBLY
1	D3526-1	RUBBER SEAL
8	MS20426AD3-3	RIVET
11	MS20426AD4-4	RIVET
4	MS20426AD4-9	RIVET
4	MS21072L06	ANCHOR NUT

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DATE 07.06.18		TITLE GPS RECEIVER HOUSING	SCALE 1:3

RELEASED
07-0803**D3514-047 TOP MOUNTED
HOUSING ASSEMBLY****NOTES:**

- 1) POWDER COAT ASSEMBLY BLACK
SANDTEX (4.3.5.7) PER DART QSI 005 4.3.
- 2) ASSEMBLE PER DART QSI 003

PARTS LIST

QTY	P/N	DESCRIPTION
X	D3514-047	TOP MOUNTED HOUSING ASSEMBLY
1	D3514-3	BOX TOP (TOP MOUNTED)
1	D3514-7	BOX BOTTOM (TOP MOUNTED)
1	D3514-9	HOOD
1	D3524-041	UPPER PLATE ASSEMBLY
1	D3526-1	RUBBER SEAL
8	MS20426AD3-3	RIVET
11	MS20426AD4-4	RIVET
4	MS20426AD4-9	RIVET
4	MS21072L06	ANCHOR NUT

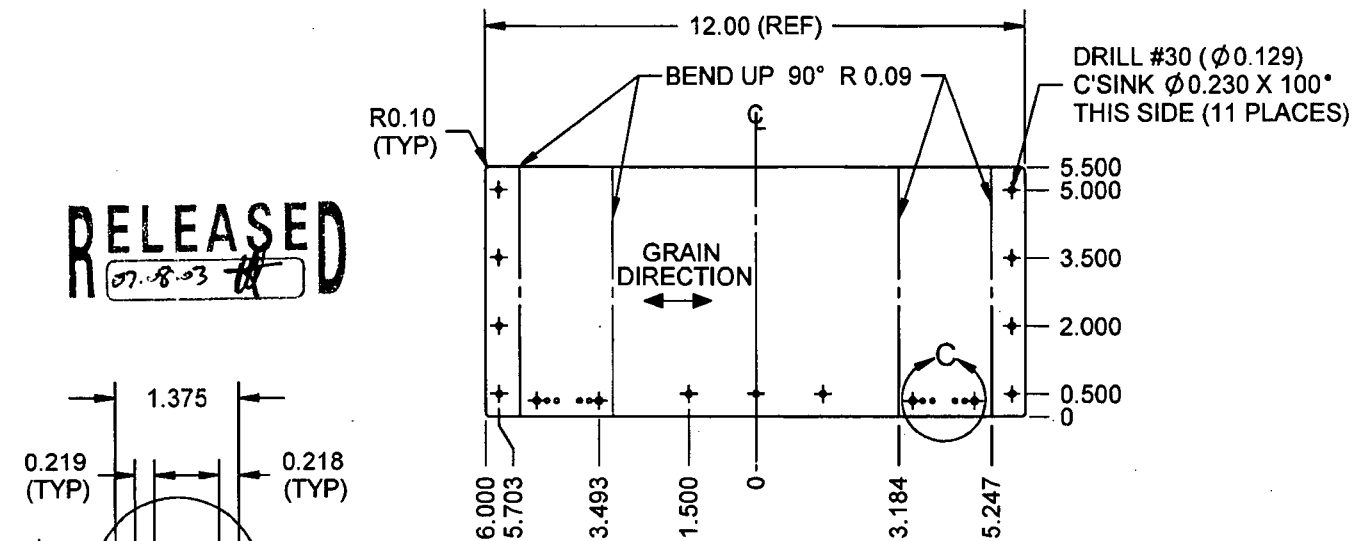
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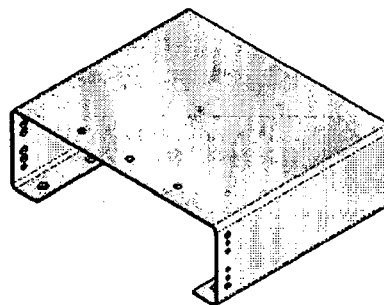


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DATE 07.06.18	TITLE GPS RECEIVER HOUSING		SHEET 5 OF 9 SCALE 1:4

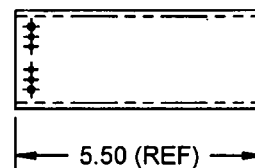
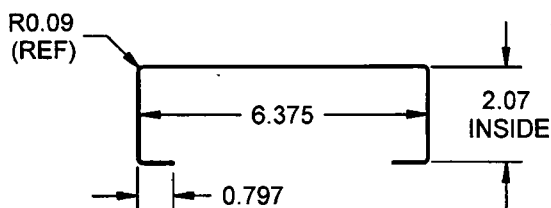
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07.08.03 [Signature]



**D3514-1F
FLAT PATTERN**



- DETAIL C
SCALE 1:2
- DRILL #27 (Ø0.144) (4 PLACES)
 - DRILL #40 (Ø0.098) C'SINK Ø0.182 X 100° THIS SIDE (8 PLACES) FOR RIVETS



D3514-1 BOX TOP (BOTTOM MOUNTED)

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT \bar{C}
- 7) C'SINKS ARE ON THE INSIDE OF PART (AFTER BENDING)

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NO. 45563

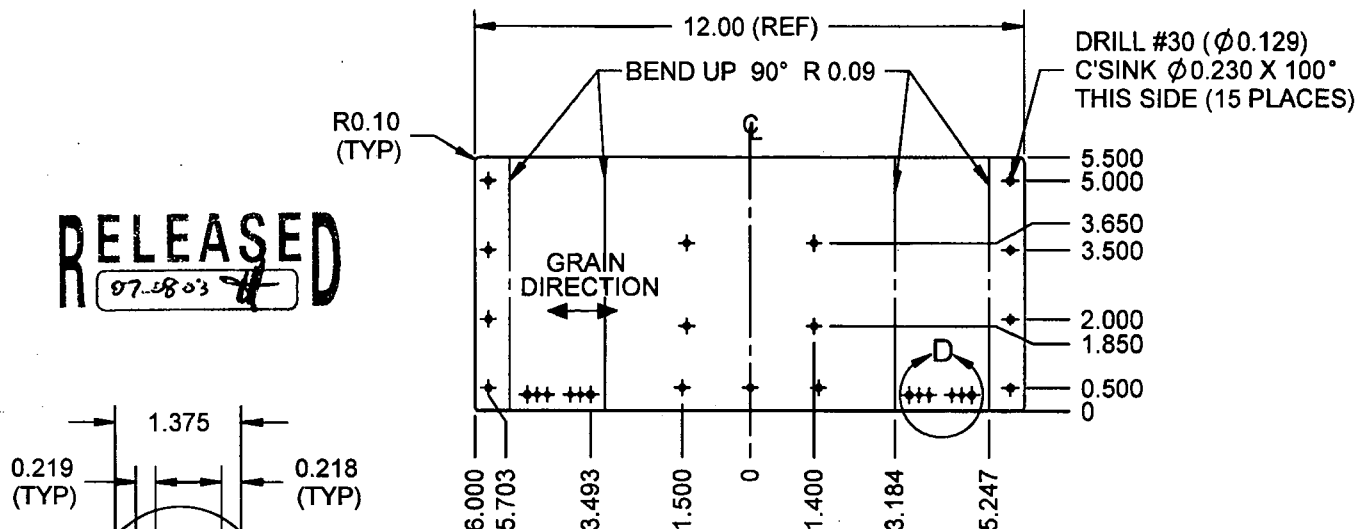
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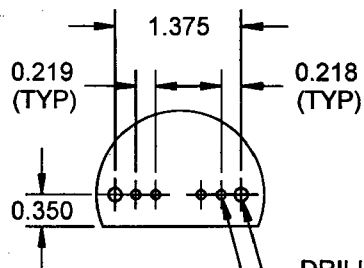


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DATE 07.06.18		TITLE GPS RECEIVER HOUSING	SCALE 1:4

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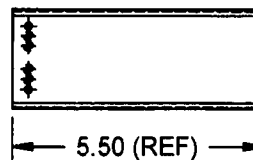
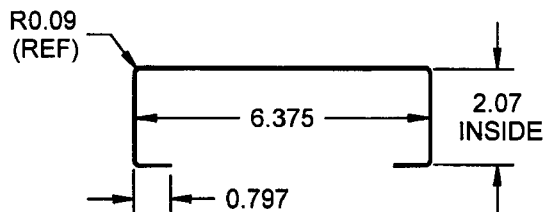
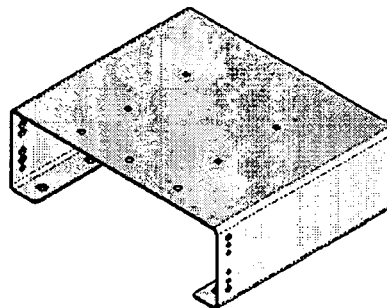
**D3514-3F
FLAT PATTERN**



**DETAIL D
SCALE 1:2**

DRILL #27 ($\phi 0.144$)
(4 PLACES)

DRILL #40 ($\phi 0.098$)
C'SINK $\phi 0.182 \times 100^\circ$ THIS SIDE
(8 PLACES) FOR RIVETS



D3514-3 BOX TOP (TOP MOUNTED)

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT ϕ
- 7) C'SINKS ARE ON THE INSIDE OF PART (AFTER BENDING)

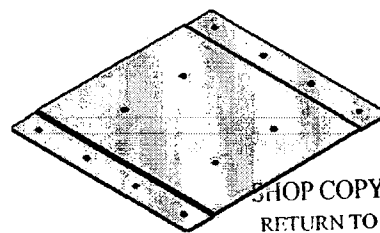
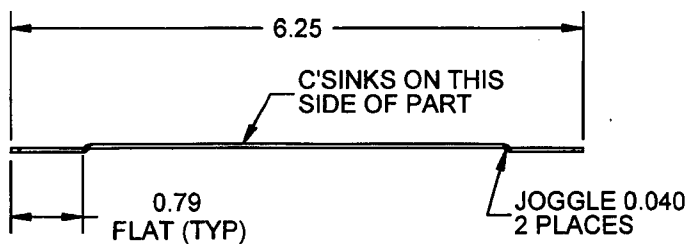
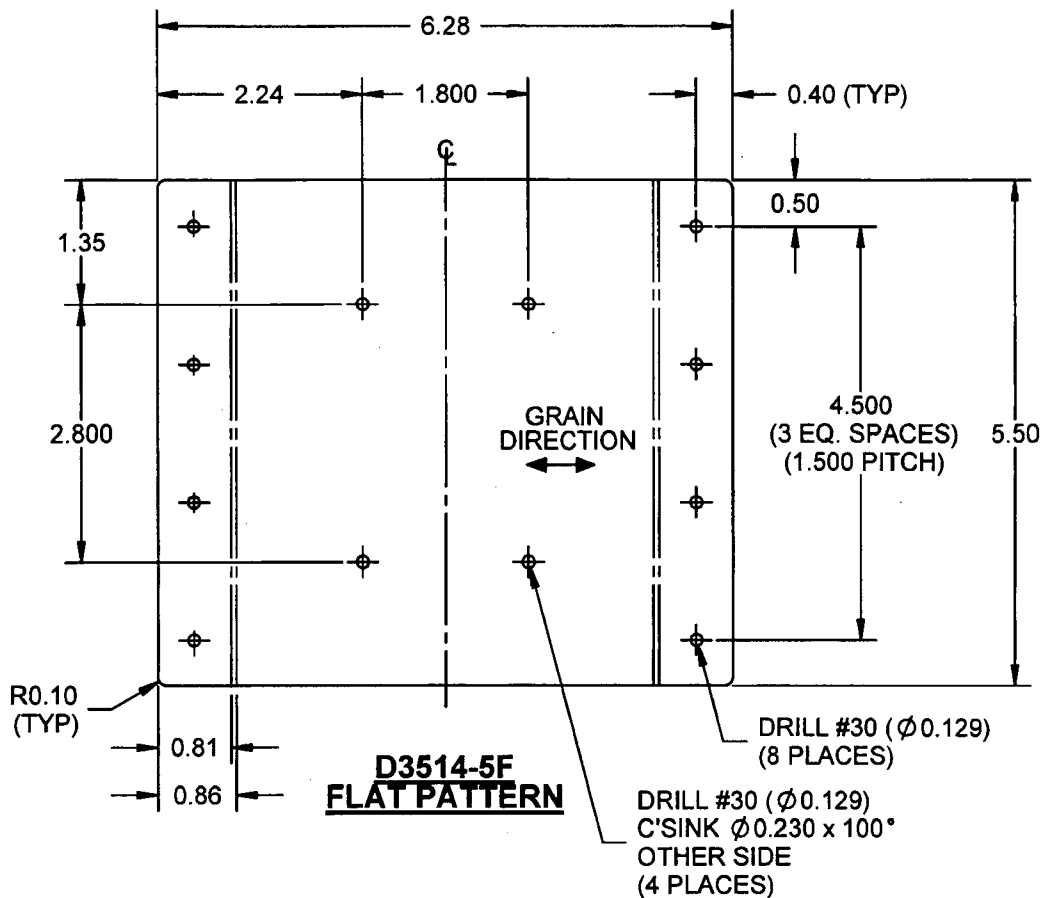
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S. J. B. TO AMENDMENT
WORK IN PROGRESS
NO. 45563

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CHECKED CE	APPROVED [Signature]	DRAWING NO. D3514
DATE 07.06.18	TITLE GPS RECEIVER HOUSING	REV. A SHEET 7 OF 9 SCALE 1:2



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WORK CENTER
NO. **455103**

D3514-5 BOX BOTTOM (BOTTOM MOUNTED)

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT CL
- 7) C'SINK ABOVE JOGGLE

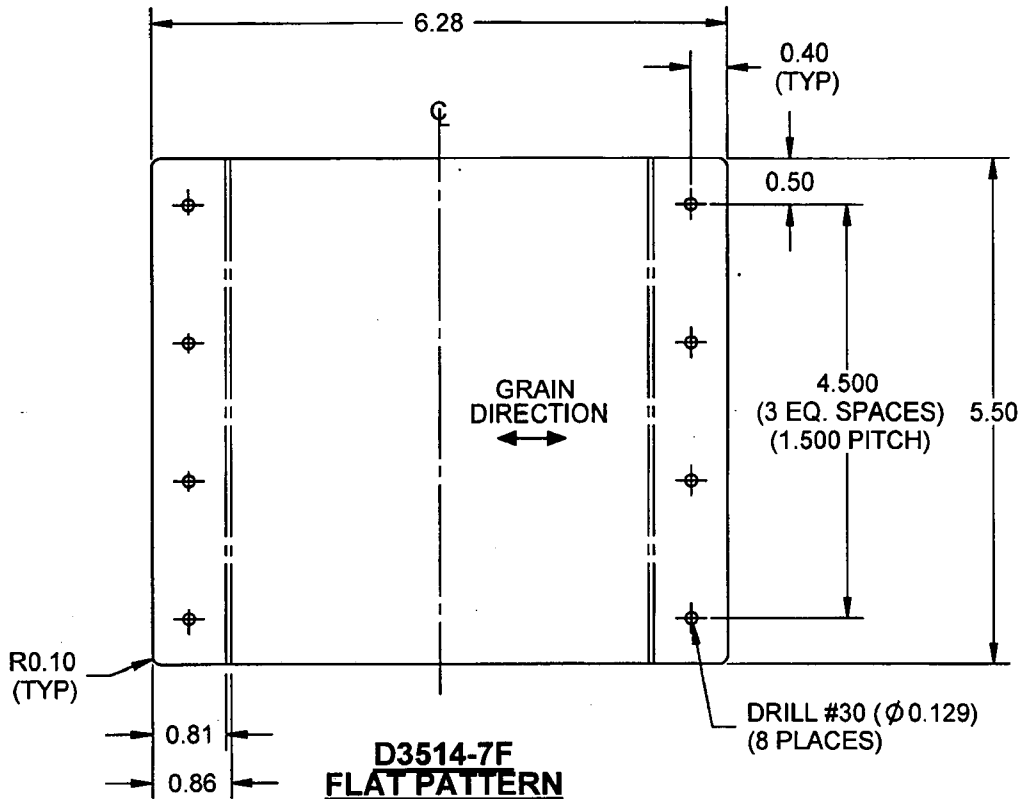
RELEASED
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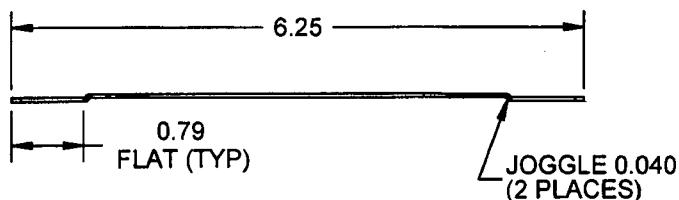
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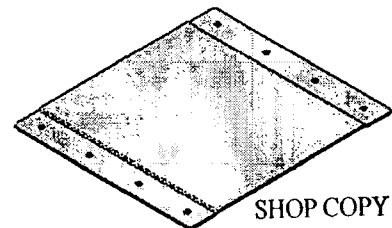
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DATE 07.06.18		TITLE GPS RECEIVER HOUSING	SCALE 1:2



**D3514-7F
FLAT PATTERN**



D3514-7 BOX BOTTOM (TOP MOUNTED)



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NO *45503*

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT C

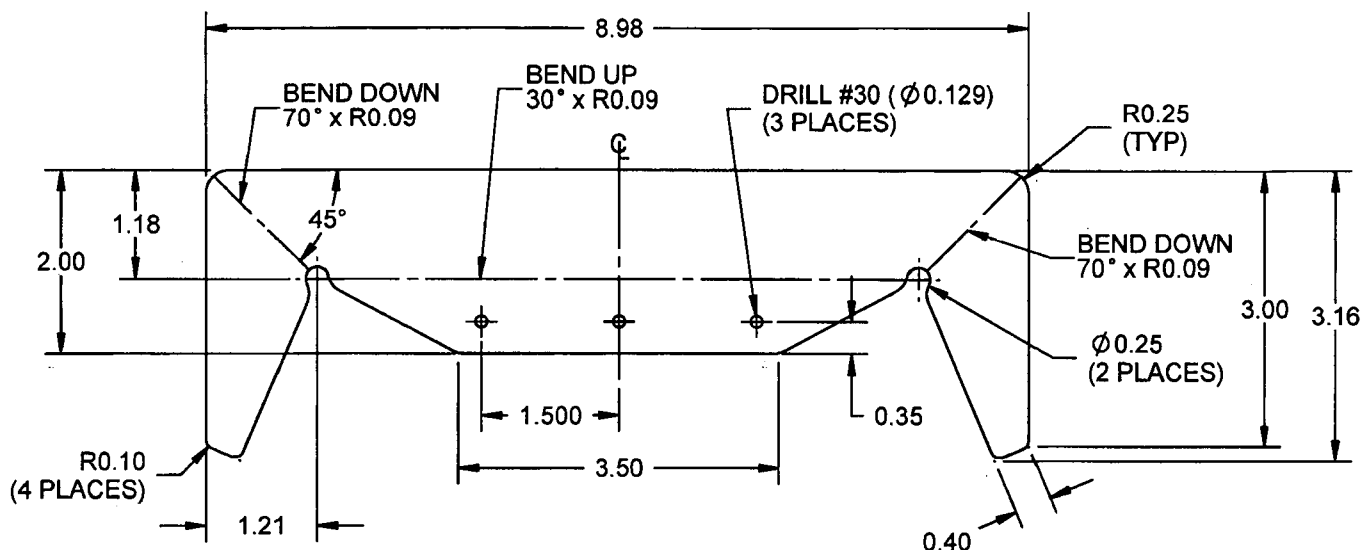
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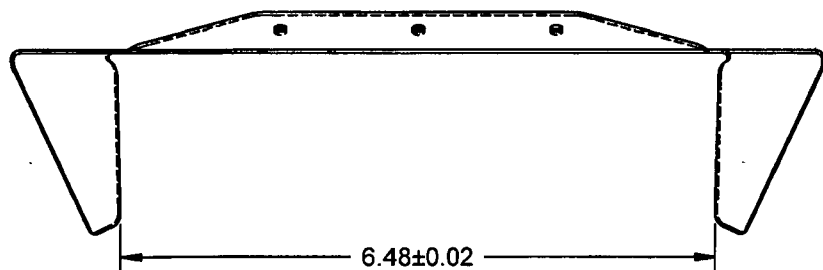
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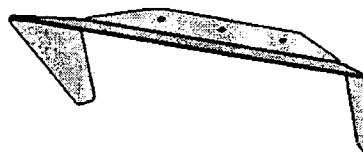
DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3514
DATE 07.06.18	TITLE GPS RECEIVER HOUSING	REV. A SHEET 9 OF 9 SCALE 1:2



D3514-9F
FLAT PATTERN



FRONT VIEW



D3514-9 HOOD

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT C

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